

Date: Tuesday, 12/20/2005 3:40:11 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: TUBE ASSEMBLY		
Job Number	: 25335					
Estimate Number	: 11551					
P.O. Number	: N/A			Part Number	: D2003047	
This Issue	: 12/20/2005		S.O. No. : N/A	Drawing Number	: D2003 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A		Type : SMALL /MED FAB	Drawing Revision	: B	
Previous Run	: N/A			Material	: N/A	
Written By	: <u>See Comment below</u>			Due Date	: 1/10/2006	
Checked & Approved By	: <u>See Comment below</u>			Qty:	5 Um: Each	
Comment	: Est. B 00.01.12 Re-format EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Open W/OType labels per PPP D2003-047

2.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 0.4865 f(s)/Unit Total : 2.4323 f(s)

304 RD Tube .500 x .035W

M18833 (2x)

Material: 1/2"AE x 0.035" wall AISI 304 SS tubing

Batch: M19196 (3x)

5

3.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut as per template D2003-047 (5.56" long)

FF 06-01-05 5

4.0	M26506	Firesleeve-crkl .375IDia
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Comment: Qty.: 0.4867 f(s)/Unit Total : 2.4334 f(s)

Firesleeve-crkl .375IDia

Cut: 5.56" long as per Dwg

M2650-6 Heat sleeve

Batch: M17521

FF 06-01-05

5

5.0	MS208198J	Sleeve
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Comment: Qty.: 2.1000 Each(s)/Unit Total : 10.5000 Each(s)

Sleeve

Pick:

Qty Part Number

Description

Batch

2 MS20819-8J

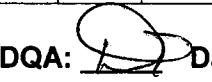
Sleeve

M16735

FF 06-01-05

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/01/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 3:40:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 25335

Part Number: D2003047

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 AN8188J Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	AN818-8J	Nut	1116735

FF 06-01-05

5

7.0 D2182045 Heat Shrink 4.5" Long



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Heat Shrink 4.5" Long

Pick:

Qty	Part Number	Description	Batch
1	D2182-045	Heat shrink	11167 M3999

FF 06-01-05

5

8.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form tube as per template D2003-047

FF 06-01-04

5

9.0 QC5 INSPECT WORK TO CURRENT STEP



Jac or 05

5

Comment: INSPECT WORK TO CURRENT STEP

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 15

10/06/05 (5)

11.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

5/26/05 (5)

06/01/06 (5)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
DATE		SHEET 1 OF 2	
99.06.08		TITLE	
		SCALE	
		206 CABIN HEATER TUBE ASSEMBLIES NTS	
A		90.04.09	NEW ISSUE
B		99.06.08	UPDATE PER TEMPLATES; ADD P/N'S; 0.025 TUBING NOW 0.035 (TSR1049)

RELEASED
99.06.08 RG

P/N	TEMPLATE	HEATSLEEVE LENGTH ¹	CUT LENGTH OF TUBE ²	MS20819-8J SLEEVE	AN818-8J NUT	MS20819-8D SLEEVE	AN818-8D NUT	MS20819-6D SLEEVE	AN818-6D NUT	DESC.	MATERIAL ^{4/87}	VENDOR OR SPEC
D2003-001	T2003-001	5.2	6.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-003	T2003-003	7.3	8.12					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-005	T2003-005	9.8	10.62					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-007	T2003-007	20.0	19.63					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-009	T2003-009	12.38	12.44					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-011	T2003-011	33.31	32.38					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-013	T2003-013	12.7	13.54					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-015	T2003-015	17.2	18.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-017	T2003-017	17.0	16.25					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-019	T2003-019	9.8	10.62		2	2				TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-021	T2003-021	N/A	2.25		2	2				TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-023	T2003-023	4.5	5.33		2	2				TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-025	T2003-025	9.8	10.60		2	2				TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-027	T2003-027	7.25	7.38		2	2				TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-029	T2003-029	17.2	18.00		2	2				TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-031	T2003-031	14.6	15.38	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-033	T2003-033	29.75	29.62	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-035	T2003-035	24.7	27.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-037	T2003-037	24.81	23.38	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-039	T2003-039	34.0	34.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-041	T2003-041	6.0	5.88	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-043	T2003-043	11.7	10.75	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-045	T2003-045	3.50	2.44	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-047	T2003-047	5.56	5.56	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-049	T2003-049	33.2	34.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-077	T2003-077	N/A	6.25				1	1		JET	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-101	T2003-101	13.25	13.13				2	2		TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-103	T2003-103	12.38	12.00				2	2		TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-105	T2003-105	10.75	10.60				2	2		TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-107	T2003-107	12.75	12.25				2	2		TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-109	T2003-109	8.25	8.125		2	2				TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-600/6
D2003-111	T2003-111	4.75	4.625		2	2				TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-600/6
D2003-116	T2003-116	4.0								HEATSLEEVE	M2650-20 CRINKLE-SOFT	STRATOFLEX
D2003-120	T2003-120	4.0								HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
D2003-14	T2003-14	4.0								HEATSLEEVE	M2650-14 CRINKLE-SOFT	STRATOFLEX
D2003-16	T2003-16	4.0								HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
D2003-205	T2003-205	9.75	9.60				2	2		TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-207	T2003-207	3.75	3.75				2	2		TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6

NON
SUBJECT
NIT

25335

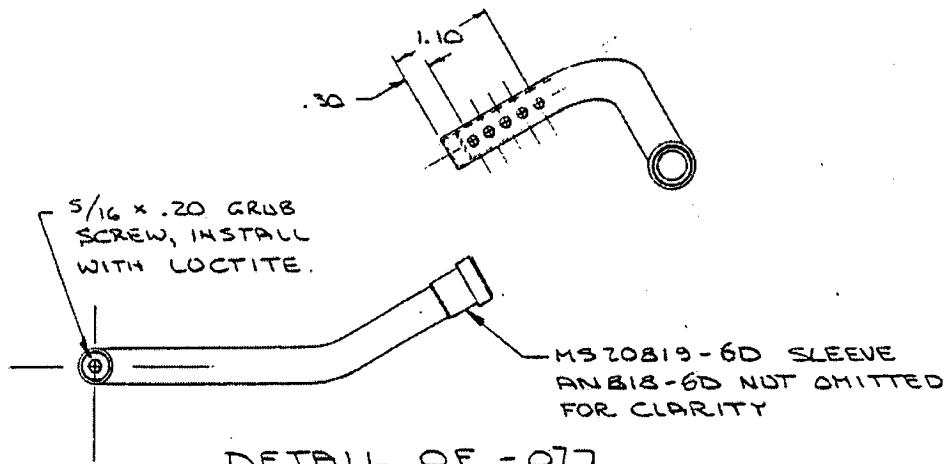


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2003
DATE	99.06.08	TITLE SCALE 206 CABIN HEATER TUBE ASSEMBLIES NTS

RELEASED
99.06.09 KE

Notes:

- (1) USE STRATOFLEX M2650-6 CRINKLE-SOFT HEATSLEEVE.
- (2) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.
- (3) TUBES TO BE FLARED 30° TO MATE WITH FITTINGS MADE TO MS33514.
- (4) ENSURE SEAMLESS TUBING IS USED.
- (5) INSTALL HEATSLEEVE OVER ALL TUBES WITH A DESIGNATED LENGTH OF HEATSLEEVE PER THE PARTS LIST.
- (6) 5052 (WW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.
- (7) 0.049 WALL THICKNESS CRES TUBING MAY BE SUBSTITUTED WHEN 0.035 IS NOT AVAILABLE.
- (8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



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WITH FOIL